

Date: Wednesday, 21/01/2009 9:05:53 AM
User: Melanie Fauteux

Process Sheet

DUPLICATE

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOOR PROTECTOR FWD LH
Job Number :	44334		
Estimate Number :	11227		
P.O. Number :		Part Number :	D32811
This Issue :	21/01/2009	Drawing Number :	D3281 REV D
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	23/12/2008	Drawing Revision :	D
Previous Run :	41849	Material :	
Written By :		Due Date :	28/01/2009
Checked & Approved By :	MF 09-01-21	Qty:	6
Comment :	Est Rev.A 04.07.01 New issue KJ/JLM Est. Rev B. 07.16.2007 Thermoform in house DL Est Rev C. 08.02.06 To reflect updated Dwg. DL Est Rev. D 08.04.15 Material Change DL		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MLEXS093F600602 GE PLASTICS LEXAN SHEET



Comment: Qty.: 4.3330 sf(s)/Unit Total : 25.9980 sf(s)
GE PLASTICS LEXAN SHEET

Material Batch Number M106751

BB 09/01/13

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

BB

09/01/13

(X6)

3.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 011

Dwg. Rev. D

Folio Rev. D

BB

09/01/13

(X6)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BB

09/01/13

(X6)

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 21/01/2009 9:05:53 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR FWD LH

Job Number: 44334

Part Number: D32811

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/01/22 X6

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 09/01/22 X6

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/22 X6

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PPP44290

S 09/01/23 X6

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26 X6

Job Completion



MF
09-01-23

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44334
Description: Floor Protector, Fwd LH		Part Number: D3281-1
Inspection Dwg: D3281	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

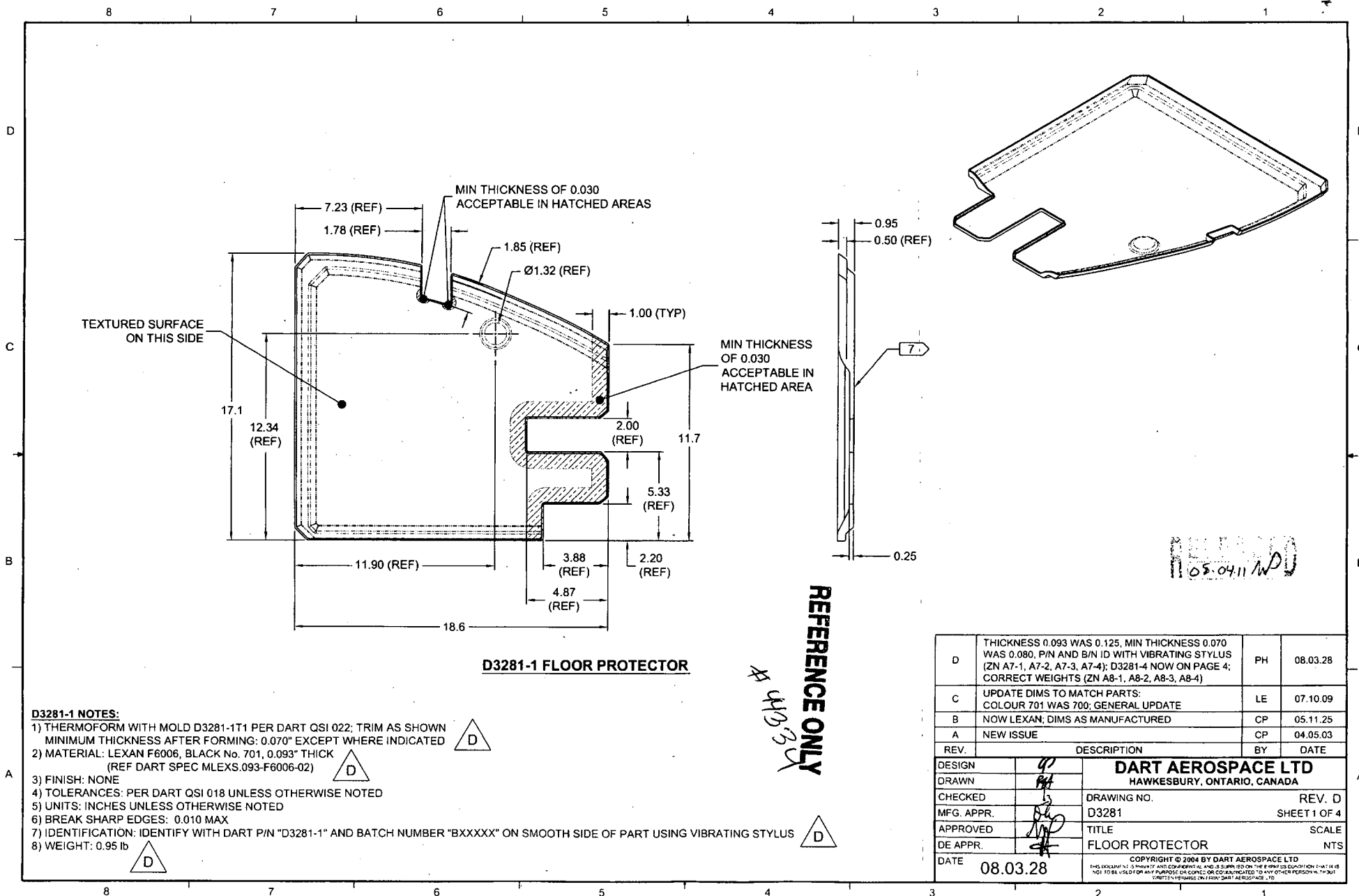
Measured by: BB	Date: 09/01/21
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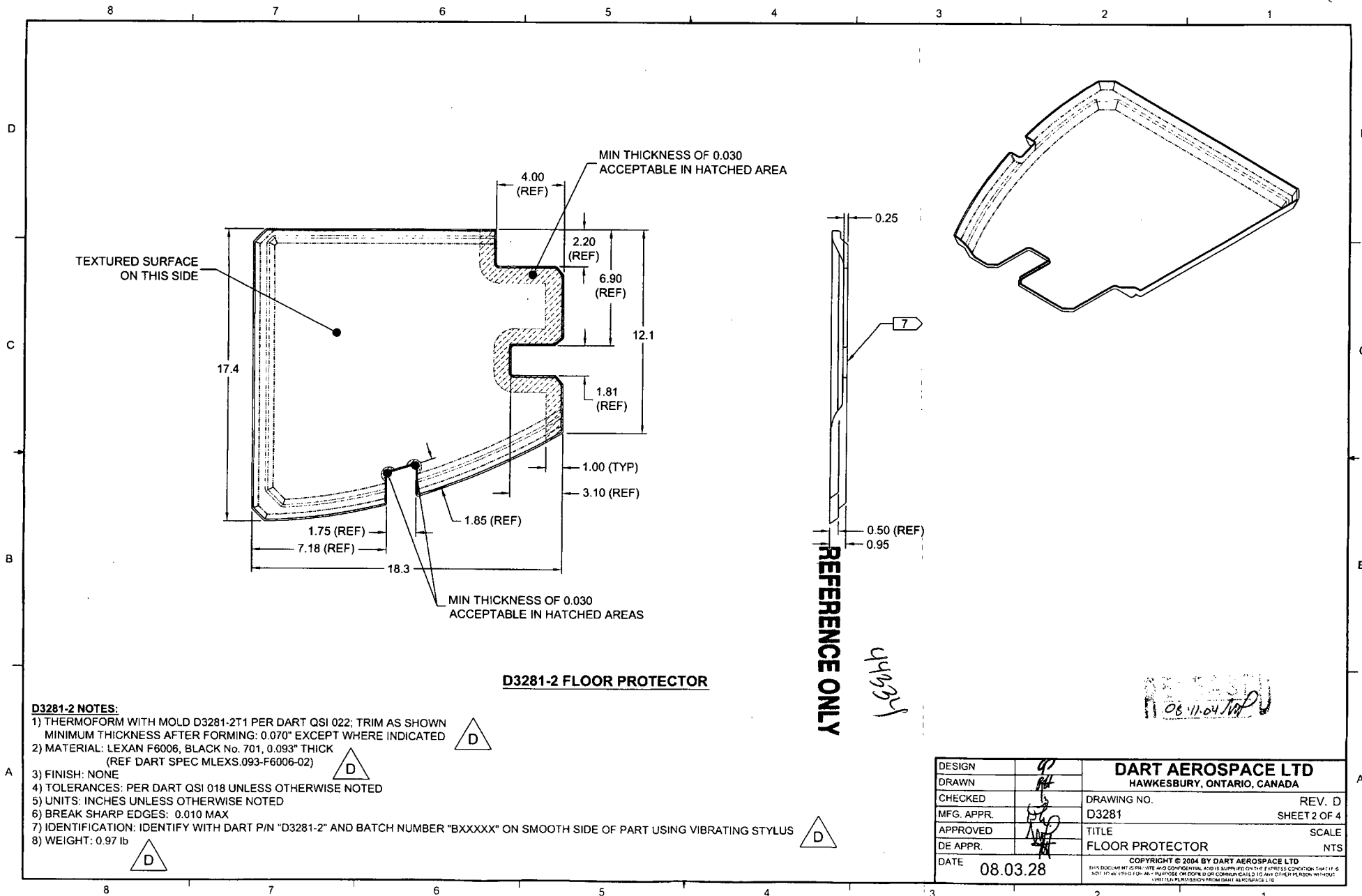
TRIMMING SECTION

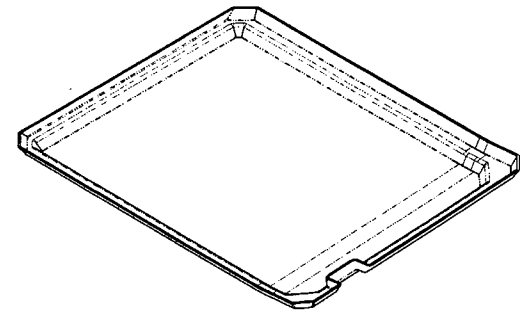
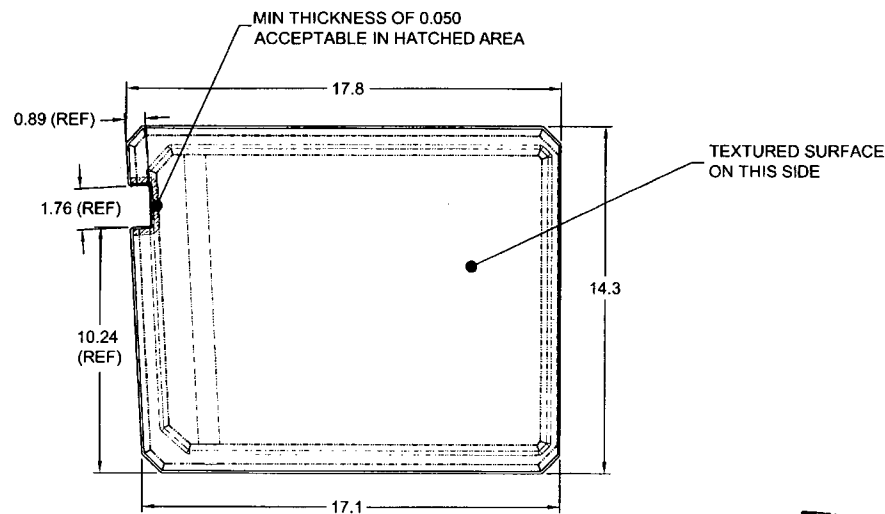
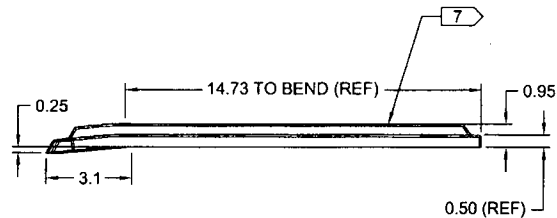
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.6	+/-0.100	18.6	✓			
17.1	+/-0.100	17.1				
11.7	+/-0.100	11.625	✓			
0.95	+/-0.030	.964	✓			
0.25	+/-0.030	.247	✓			
0.030	Min	.063	✓			
0.070	Min	.086	✓			

Measured by: BB	Date: 09/01/21
Audited by: Dh	Date: 09/01/21
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	







D3281-3 FLOOR PROTECTOR

D3281-3 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

REFERENCE ONLY

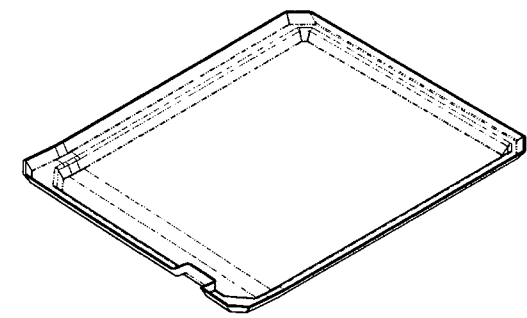
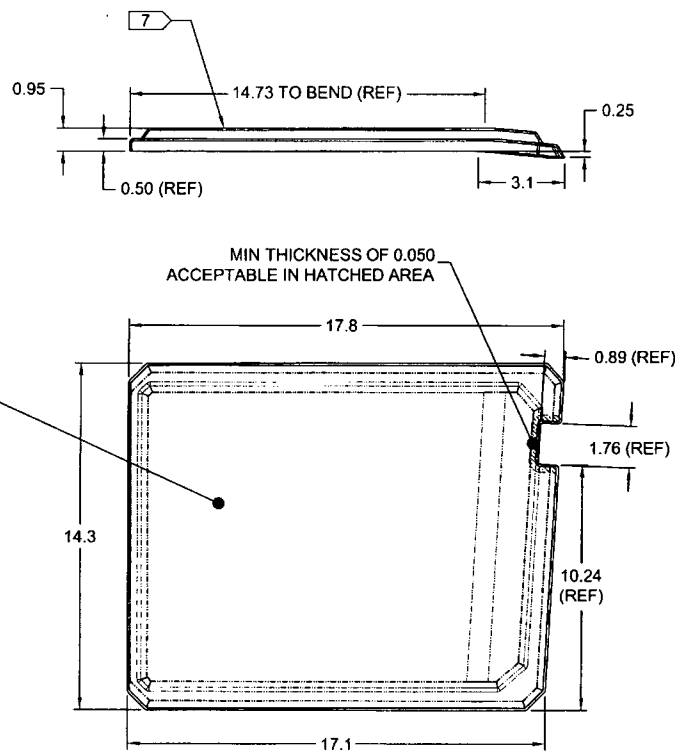
08-04-11 MJD

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	13	DRAWING NO.	REV. D
MFG. APPR.	120	D3281	SHEET 3 OF 4
APPROVED	120	TITLE	SCALE
DE APPR.	120	FLOOR PROTECTOR	NTS
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8 7 6 5 4 3 2 1

D
C
B
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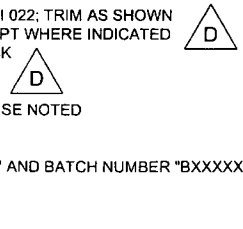
D
C
B
A



D3281-4 FLOOR PROTECTOR

D3281-4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb



REFERENCE ONLY
449334

08-04-11 M.D.

DESIGN	97	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3281	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
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8 7 6 5 4 3 2 1